

Preparation description: Aluminium

General Information:

Untreated Aluminium is divided into soft and hard aluminium. The surface of pure aluminium is normally protected by a thin layer of oil; use selected cleaning products to remove the oil coat. Coated aluminium parts which are to be recoated, must have any old unsound coating completely removed by sanding, scuffing or suitable beam technology for the new sustainable coating.

An anodized coated surface is very hard and almost impossible to create a suitable key for painting., Therefore, for a sustainable new coating, avoid applying paint products to anodized coated aluminium..

It is very important to use the correct PPE (personal protective equipment) such as gloves, glasses, mask, and protective overalls.



Use only the appropriate tools and equipment with anti-static properties to avoid cross contamination (sanded aluminium is highly explosive!), and use certified grinding media. Avoid contact corrosion.

Aluminium should not be exposed to temperature fluctuations before coating, (dew point - the atmospheric temperature (varying according to pressure and humidity) below which water droplets begin to condense and dew can form).

Use slower evaporating cleaners to avoid condensation on the surface. Do not apply any paint products to objects which are subject to the influence of moisture. Recoating must be executed without any undue delay (within 60-90 minutes), with direct lacquers or primer and topcoat.




Cleaning

Products: RS605/607/609 Universal Reducer or AD690 Degreaser

	to refine 1x	Use the recommended products with a brush or soaked cloth/rag to remove the residues on the surface. If the contamination level is too high, repeat the cleaning step.
	wipe dry	With a clean dry cloth, wipe the dissolved contaminant from the surface, repeat until the surface is dry. Purity test-wipe the surface with a white clean cloth, repeat this step until the cloth remains clean after wiping, this ensures there is no contamination left on the surface.


Sanding


Products: P180 – P240 (eccentric) grinding machine or scuff with Scotch-Brite


	Beam technology	Recommended methods for aluminium are: Dry ice blasting or non-metal substrates with low pressure due to the risk of deformation.
	sanding	Hard aluminium has to be sanded after the cleaning process with an eccentric grinding machine (<5mm rotary lift unit), a P180 sanding disk and a special aspirator for aluminium. Treat soft aluminium as hard aluminium, but use a P240 sanding disk.
	scuffing	With a nylon-perlon abrasive part to roughen the aluminium surface, e.g. a Fine/Ultra fine scuff pad (do not use wire wool or a similar metal-content medium). Treat edges and corners with care.
After grinding/scuffing, the bare metal of the aluminium surface must appear. (Weathering -, corrosion residues and other impurities must not be visible).		

Cleaning

Products: RS605/607/609 Universal Reducer or AD690 Degreaser


	cleaning with pressurized air	The sanded/scuffed aluminium surface must be cleaned with compressed air so that loose abrasive particles which were not vacuumed by the suction device are removed.
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	<p>wipe dry</p>	<p>With a clean dry cloth, wipe the dissolved contaminant from the surface, repeat until the surface is dry. Purity test-wipe the surface with a white clean cloth, repeat this step until the cloth remains clean after wiping. This ensures there is no contamination left on the surface.</p>
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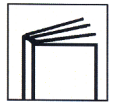
Coating


Depending on the recommendation, such as a HVLP/LVLP/RP spray gun or low-high pressure pump.

	<p>to coat</p>	<p>Application of direct to metal topcoats, primer , primer surfaces with basecoat and clearcoat or topcoat.</p>
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Please select a suitable paint system from the “System Technique” datasheets.

Further Information

		<p>For more information see:</p> <ul style="list-style-type: none"> • Information at CRS (ICRIS, COINS, Valspar refinish) • Purple Box starter pack information sheets • Information on our web page (www.valsparindustrialmix.com) <ul style="list-style-type: none"> ○ Technical Information ○ Technical Data Sheets
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	<p>This preparation description has been developed in order to enable professional users to maintain high quality standards for Valspar (Light) Industrial Mix and Commercial vehicle systems.</p> <p>Precautions: During application all health and safety measures referring to the use and handling of coating materials are to be observed, e.g. existing regulations issued by the trade associations in the chemical industry. For health and safety information, please refer to the Material Safety Datasheet (MSDS). Information is also available on our web page: www.valsparindustrialmix.com</p> <p>Note: The products listed are intended only for the professional user and for professional use. All recommendations given in writing on the use of our products to customers or users are non-binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from independently checking whether our products are suitable for the intended purpose. The durability of the coating system largely depends on thorough preparation of the surface. Furthermore, our uniform terms of delivery and payment are applicable.</p> <p>With the publication of this Technical Data Sheet, all previous versions regarding this product are no longer valid.</p>
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